

Date: Tuesday, 09/09/2008 10:43:09 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET
Job Number	: 41624		
Estimate Number	: 10819		
P.O. Number	:	Part Number	: D130701041
This Issue	: 09/09/2008 S.O. No. :	Drawing Number	: IIN D130-701 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 09/09/2008 Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 41624	Material	:
Written By	:	Due Date	: 19/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 08.9.09</u>		
Comment	: Est Rev:A 02.12.04 New issue KJ/RF Est Rev:B 07-06-28 As per Rev B JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



JLD 08.8.28

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D130-701-041 CHG003

5 08/10/09

2.0	41624A	350/212/130 BASKET LID
-----	--------	------------------------

**Comment:** Sub-Component 350/212/130 BASKET LID1 x D2512 Batch: 41624A

3.0	41624B	BASKET BASE ASSEMBLY EC 130
-----	--------	-----------------------------

**Comment:** Sub-Component BASKET BASE ASSEMBLY EC 1301 x D3172-041 Batch: 41624B

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Assembly Kit

5.0	D2022101	Spacer
-----	----------	--------

**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	<u>39880</u>

Revised ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: HELI UTILITY BASKET

Job Number: 41624

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2258220

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description

Batch

1 D2258-220 Label

41266

[Signature]

7.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description

Batch

1 D2332-041 Prop Assy

40718

[Signature]

8.0

D2512

Basket Lid 205/350



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number Description

Batch

1 D2512 Basket Lid Assy

also at step 20 See 10/08

9.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description

Batch

1 D2530 Handle Assy

40758

[Signature]

10.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description

Batch

2 D2535 Spring

39670

[Signature]

11.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description

Batch

2 D2537 Bushing

39153

[Signature] 8/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 41624

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 D2931 Bumper 21133

Lu

13.0

D3172041

Basket Base Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number Description Batch
1 D3172-041 Basket Base Assy ~~M157737~~

n/lt at step # 3.0 Sep 10/08

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 AN3-16A Bolt M157737

Lu

15.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
2 AN4-7A Bolt M158077

Lu

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 AN4-22A Bolt M157715

Lu

17.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch
1 AN4-24A Bolt M154547

Lu step 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 41624

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt

M108538 PD

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416 Washer

M108827 LU

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer

M108583 LU

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M109059 LU

22.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer

M108335 LC 8/14/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI UTILITY BASKET

Job Number: 41624

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

4 AN970-4

Washer

M108928

[Signature]

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 MS21042L3

Nut (or -3)

M108707

[Signature]

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

4 MS21042L4

Nut (or -4)

M108148

[Signature]

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

4 MS21042L5

Nut (or -5)

M108161

[Signature]

27.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 MS20600AD4W3 Rivet

18071

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: HELI UTILITY BASKET

Job Number: 41624

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg IIN-D130-701

FZ 08/10/08 (P)

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/08 (X)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

31.0

D3173041

Beam Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3173-041 Beam Assembly

37157 14

41268 14

EW

32.0

D3177041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3177-041 Bracket Assembly

24923

R

33.0

D3177043

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3177-043 Bracket Assembly

37158

C

34.0

D3180041

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3180-041 Strut Assembly

1341270

P 08/14/09 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 41624

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D31811

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3181-1 Bushing 18770

lu

36.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-7A Bolt M108077

lu

37.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-12A Bolt M108672

lu

38.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN5-10A Bolt M108827

lu

39.0

AN523A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-23A Bolt M19278

lu

40.0

AN960JD416

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

5 AN960JD416 Washer M108827

lu 8/10/08 lu

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 41624

Part Number: D130701041

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD516

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

12 AN960JD516

Washer

M109059

[Handwritten signature]

42.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21042L4

Nut (or -4)

M108145

[Handwritten signature]

43.0

MS21042L5

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

6 MS21042L5

Nut (or -5)

M108161

[Handwritten signature]

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

[Handwritten signature]

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-701-041

Location:

PPP Rev:

[Handwritten 'C']

[Handwritten '8/10/9']

[Handwritten '12']

[Handwritten 'JRP']

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

[Handwritten signature]

Job Completion



[Handwritten 'MF 08-10-09']

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

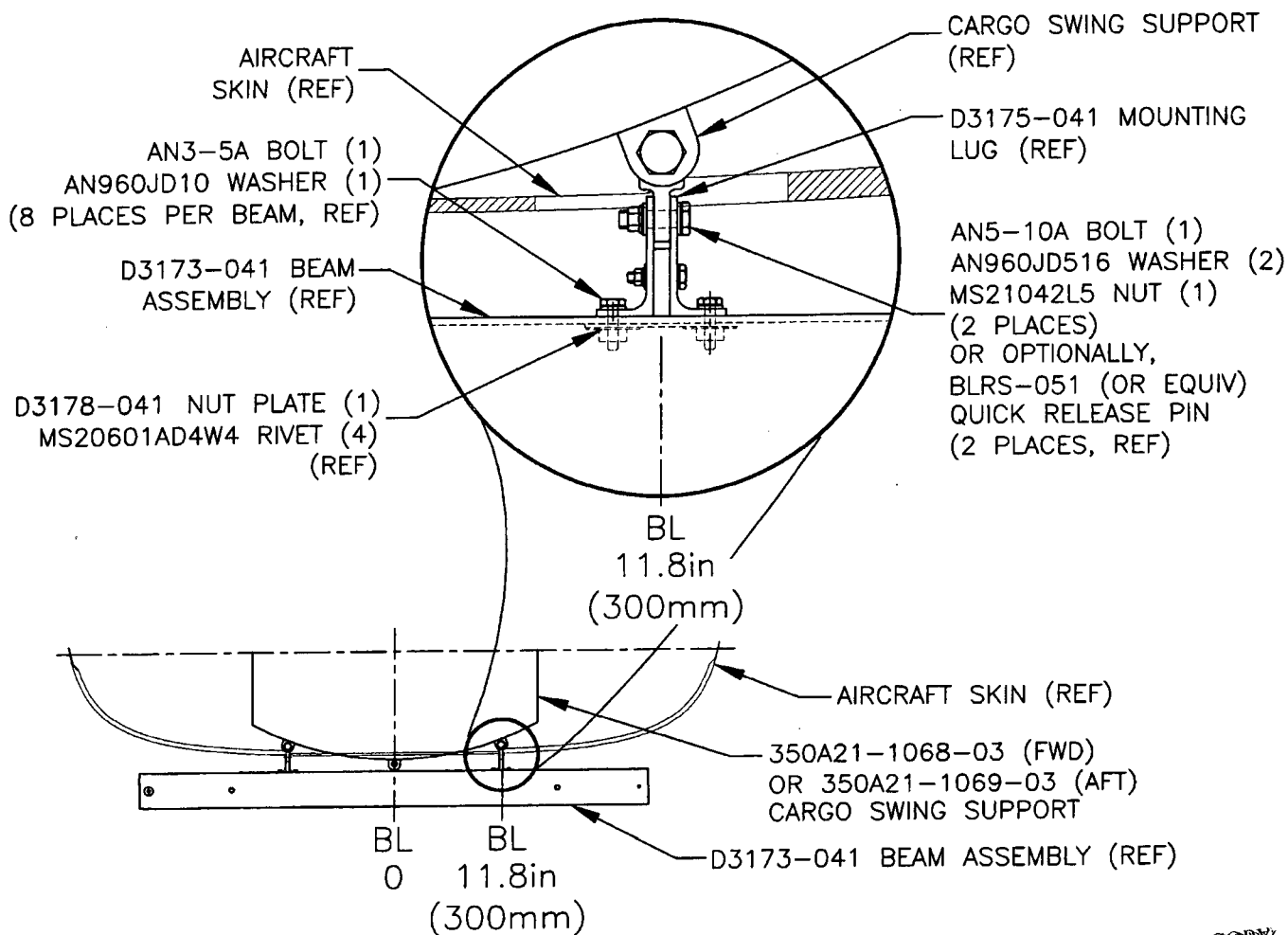


Figure 2 – Typical D3173-041 Beam Installation

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Revision: **B**
Date: 03.01.07

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NO. 41024

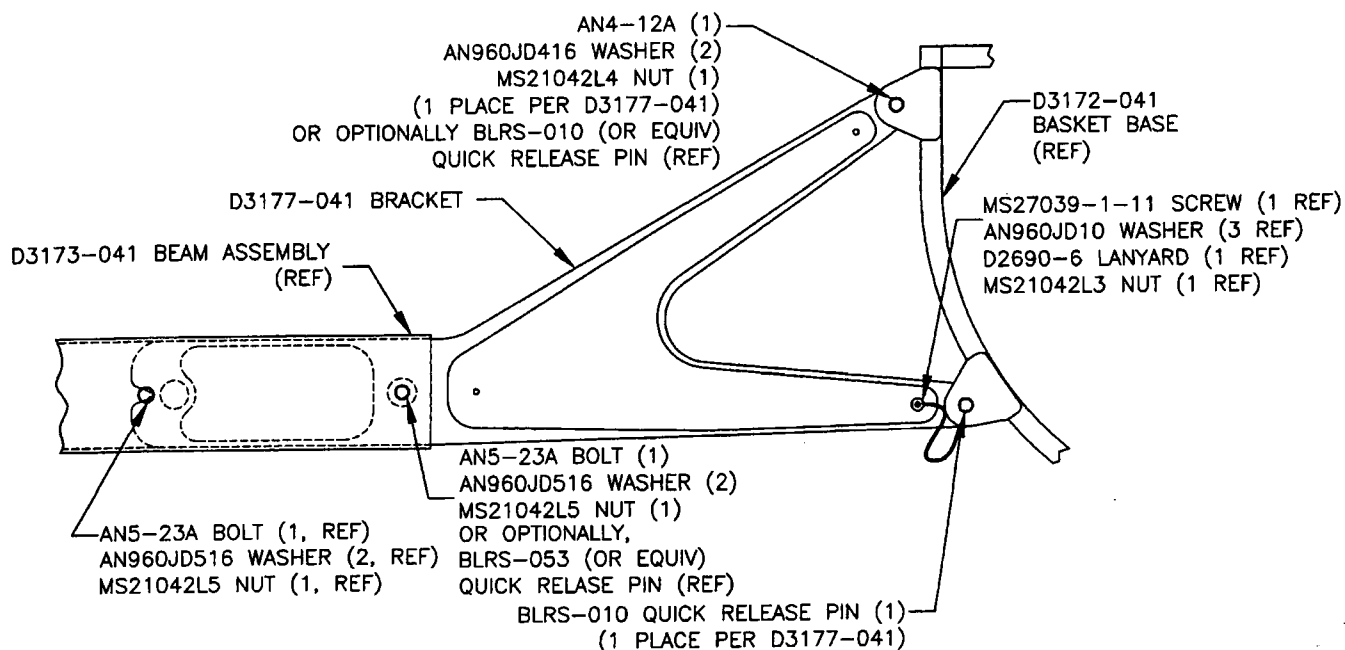


Figure 3 - Fwd Bracket Attachment

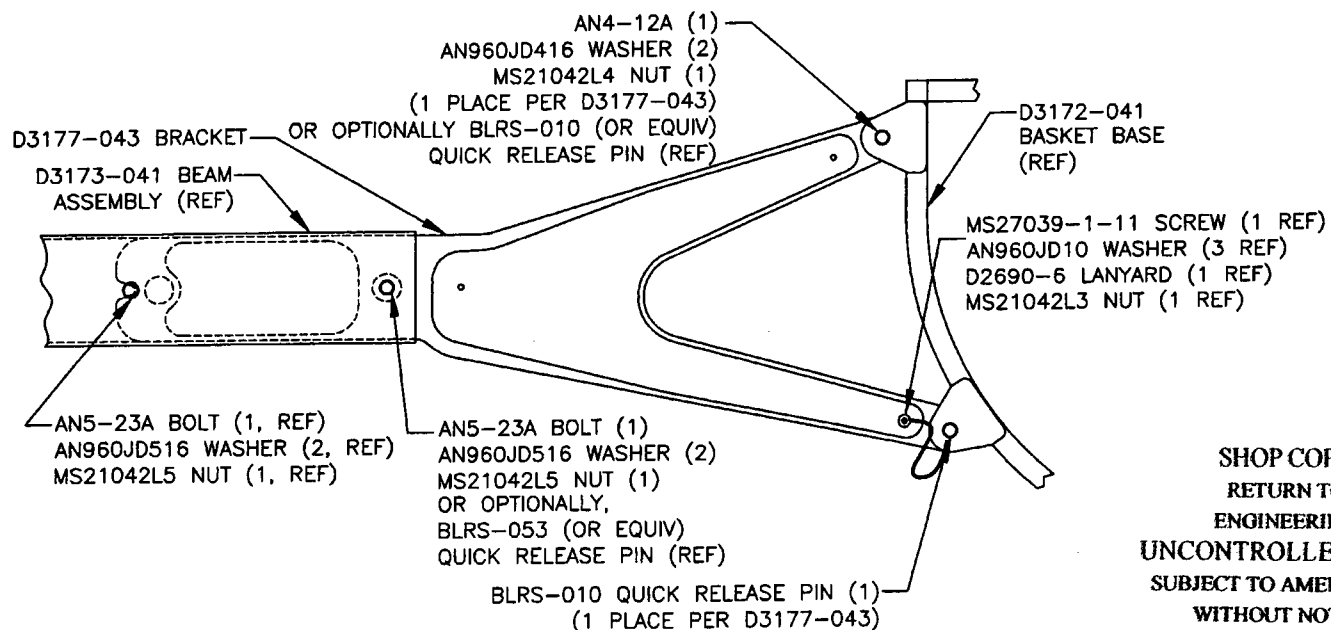
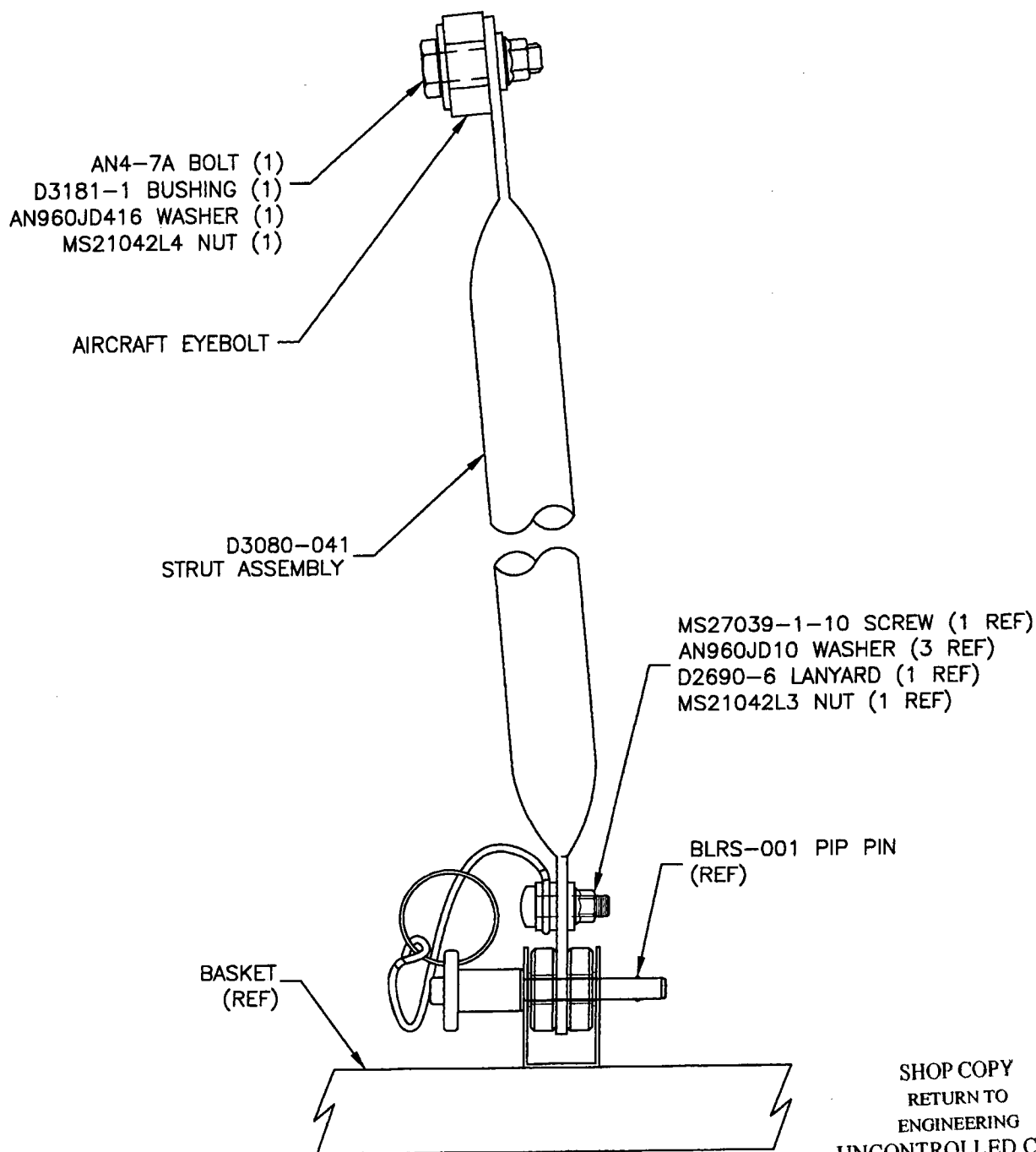


Figure 4 - Aft Bracket Attachment

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**Figure 5 – Strut
(From Figure 1)**

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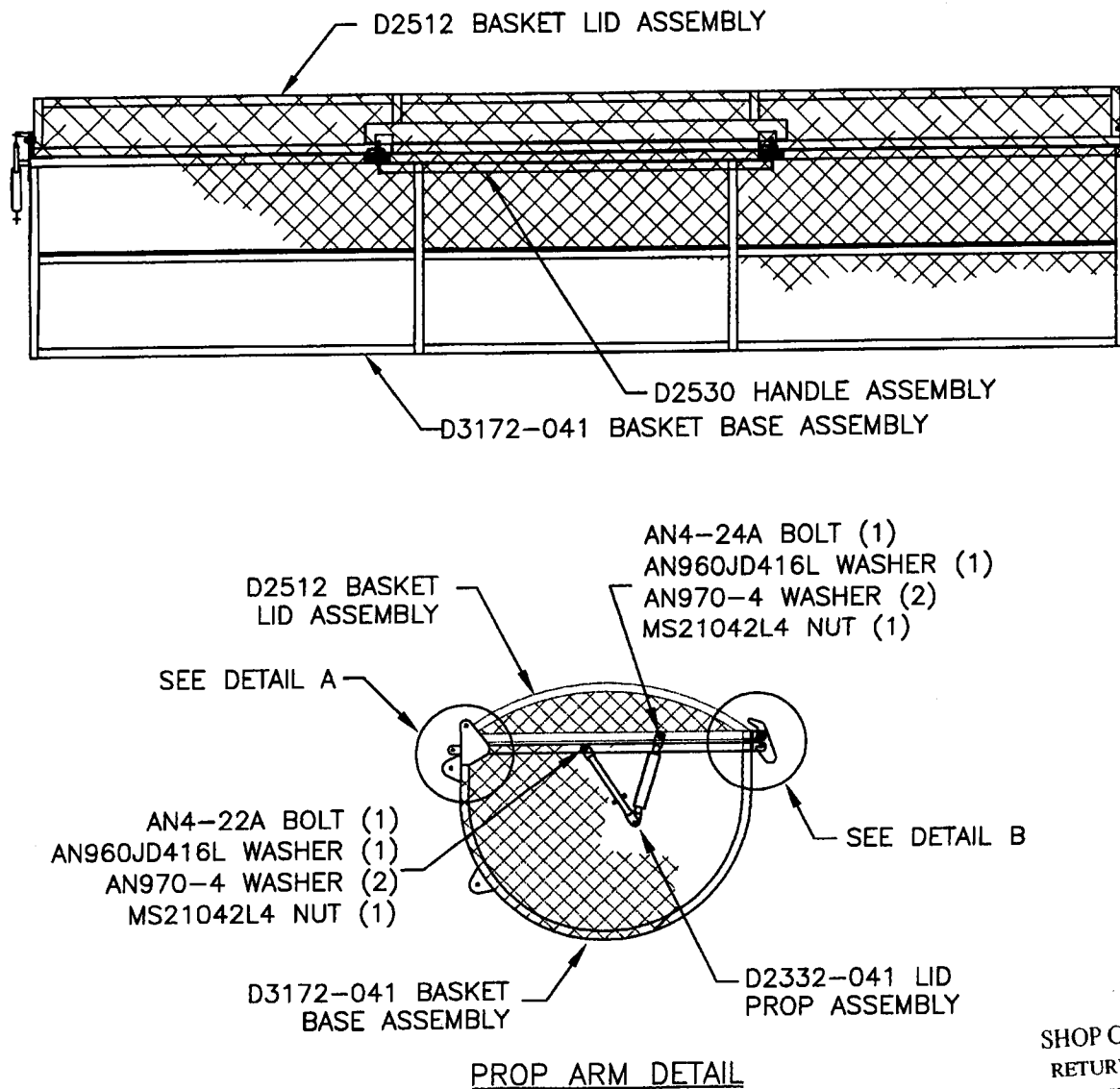


Figure 6 – Basket Replacement Parts

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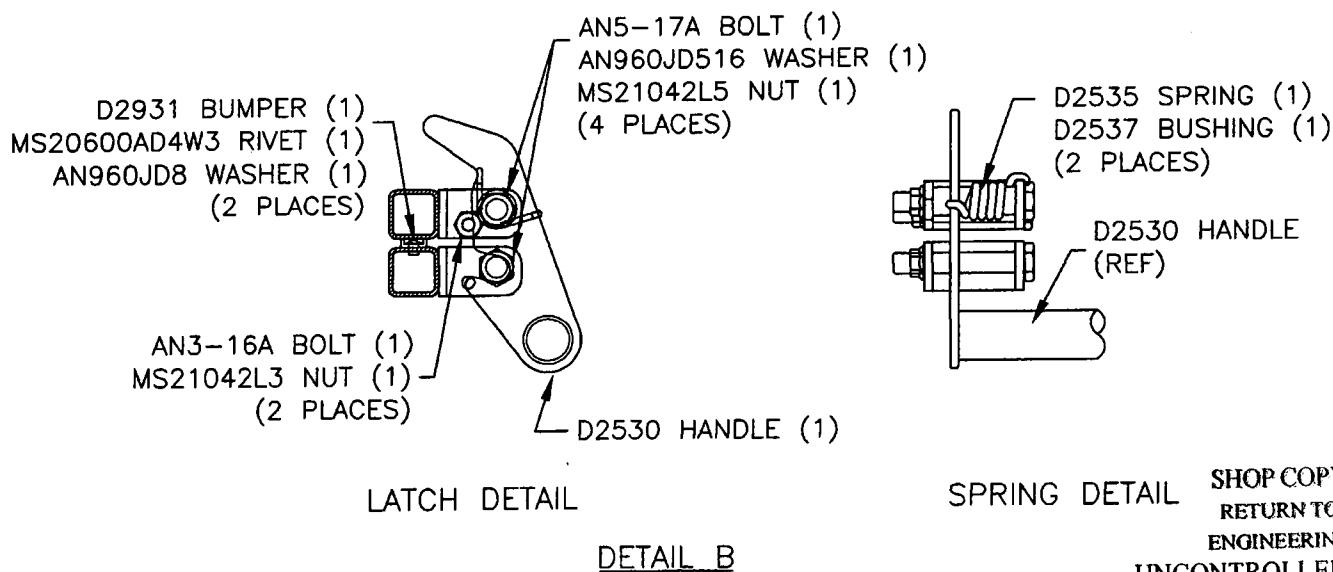
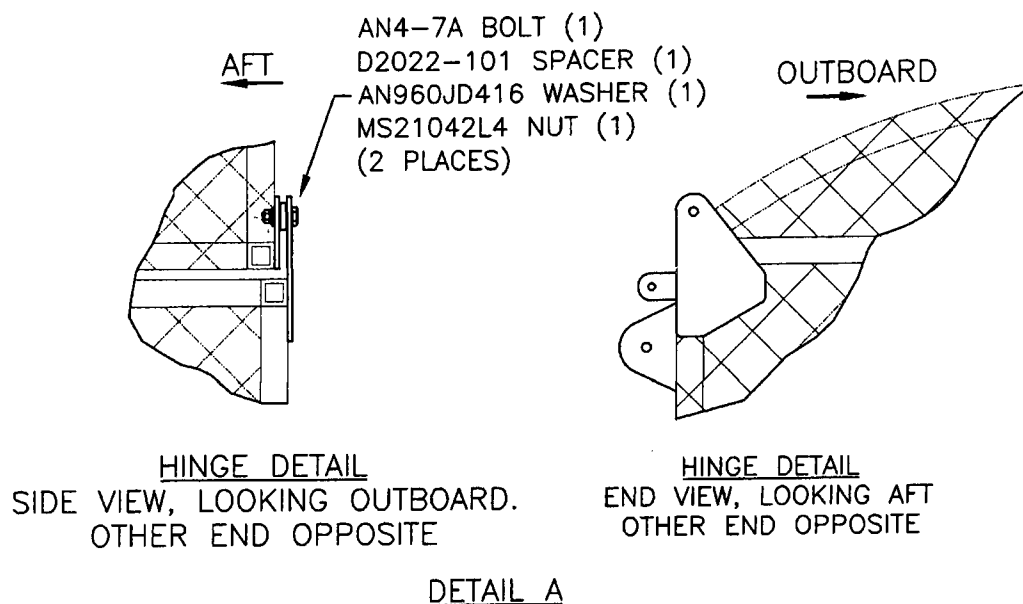


Figure 7 - Basket Replacement Parts continued

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NO. 41624

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D130-701-041 (LH installation)	120 lb 54 kg	- 47.4 in - 1.20 m	- 5688 in-lb - 64.8 m-kg	133.9 in 3.40 m	16068 in-lb 183.6 m-kg
D130-701-041 (RH installation)	120 lb 54 kg	+ 47.4 in + 1.20 m	+ 5688 in-lb + 64.8 m-kg	133.9 in 3.40 m	16068 in-lb 183.6 m-kg
2 x D130-701-041 (LH & RH installation)	224 lb 102 kg	0.0 in 0.00 m	0 in-lb 0.0 m-kg	133.9 in 3.40 m	29994 m-kg 346.8 m-kg

5. PARTS LIST

Qty -041	Part Number	Description
X	D130-701-041	HELI-UTILITY-BASKET
2	D2022-101	SPACER
1	D2258-220	LABEL
1	D2332-041	PROP ASSEMBLY
1	D2512	BASKET LID ASSEMBLY
1	D2530	HANDLE ASSEMBLY
2	D2535	SPRING
2	D2537	BUSHING
2	D2931	BUMPER
1	D3172-041	BASKET BASE ASSEMBLY
2	D3173-041	BEAM ASSEMBLY
1	D3177-041	BRACKET ASSEMBLY
1	D3177-043	BRACKET ASSEMBLY
1	D3180-041	STRUT ASSEMBLY
1	D3181-1	BUSHING
2	AN3-16A	BOLT
2	AN4-12A	BOLT
1	AN4-22A	BOLT
1	AN4-24A	BOLT
3	AN4-7A	BOLT
4	AN5-10A	BOLT
4	AN5-17A	BOLT
2	AN5-23A	BOLT
7	AN960JD416	WASHER
2	AN960JD416L	WASHER
16	AN960JD516	WASHER
2	AN960JD8	WASHER
4	AN970-4	WASHER
2	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
7	MS21042L4	NUT (OR MS21042-4)
10	MS21042L5	NUT (OR MS21042-5)

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